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RB H4713
Job Sheet 184330



Part No: RB H4713

Job Qty: 1 ea 10

DAS
21
9-89

Part Name: Drain Hose



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/5/18

Job Tracking No:

Created By: Logan David

Due Date: 10/29/18

Type: SOLD

Description:

Note: DWG RB H4713 Rev 4 IPP Rev A 18.02.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	10/29/18	10/29/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	1 pcs	10/29/18	10/29/18	0.00	0.13	Small Fab-9		MLL DAS
110	QC	1 pcs	10/29/18	10/29/18	0.00	0.00	QC5		DAS 38
130	Packaging	1 pcs	10/29/18	10/29/18	0.00	0.00	Packaging3-2		28 9-89
140	QC21-FG	1 Ea	10/29/18	10/29/18	0.00	0.00	QC21		9-89

Part Op 100 - Assemble and pack as per DWG. Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Descriptions: Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable).

130 - Identify and Stock

DAS

21

9-89

JAN 10 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
2044T47	Tube Ø1.09	.3500 ft (.35 ea)	90-Start up Operation	5016490
2044T67	Cap Ø1.09	2 Ea (2 ea)	90-Start up Operation	5137367
51495K116	COUPLING 1/2" NCKL PLTD BRASS	1 Ea (1 ea)	90-Start up Operation	5089132 5x 5133294
K010-0608	Hose Ø1/2 OD x Ø3/8 ID	6 ft (6 ea)	90-Start up Operation	5134727
PAD210	Foam Ø1 X 1	.0070 sf (.007 ea)	90-Start up Operation	5021250
RB H4713-1	Drain Hose Body	1 Ea (1 ea)	90-Start up Operation	5138603
9263K642	O-Ring	1 Ea (1 ea)	90-Start up Operation	5078377

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	2044T47	0	26	0
	2044T67	2	133	0
	51495K116	1	50	0
	9263K642	1	45	0
	K010-0608	6	303	0
	PAD210	0	12	0
	RB H4713-1	1	13	0

5113238 3x
5137369 1x



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AEROSPACE

Container No: S143274

Part: RB H4713

Job No: 184330

Serial No/Batch: S143274

Revision: 4

Inspector:

Exp Date:

Instructions:

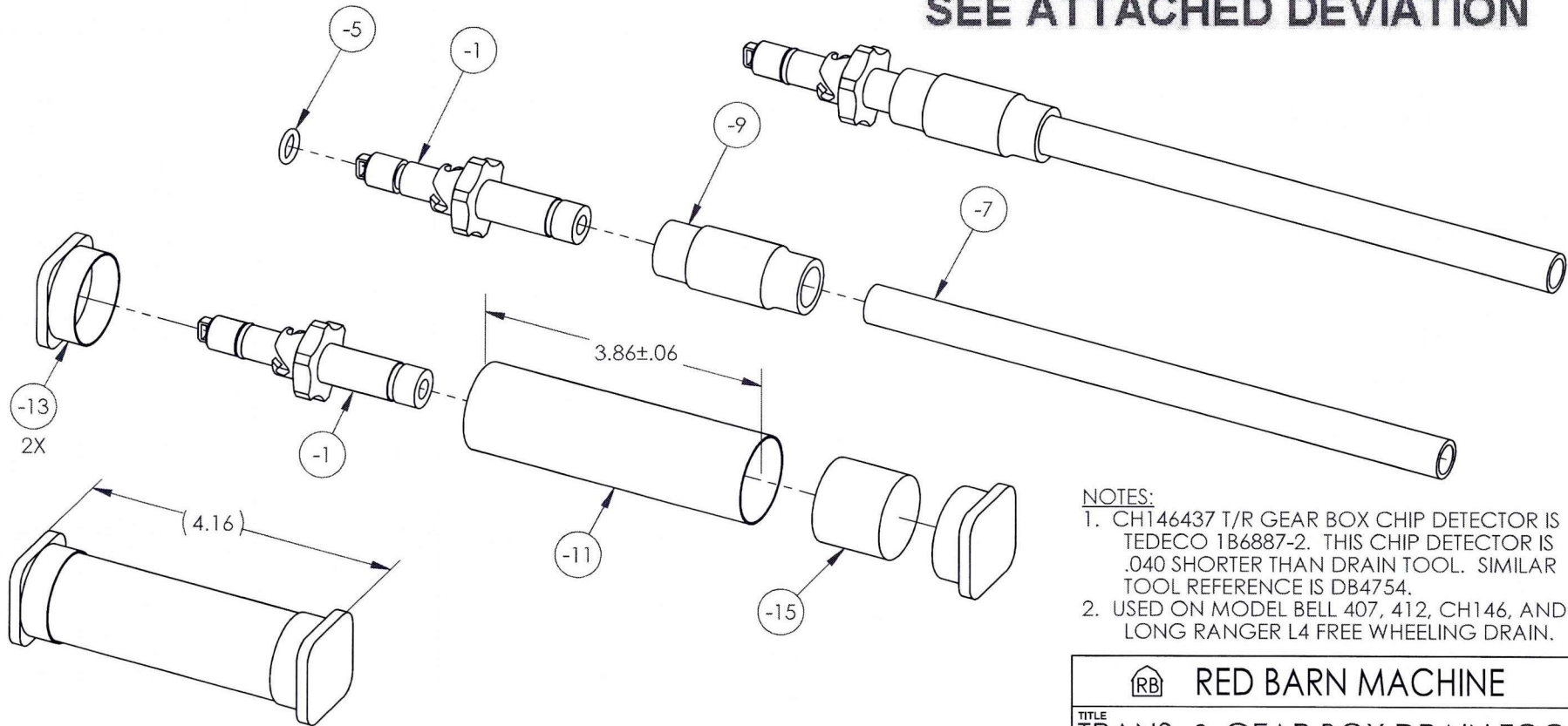
Date: 01/09/19

PAQ 08-6
PAQ 08-6
85 08-6

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	CHANGED HOSE LENGTH FROM 24 in. to 6 ft.	4/15/08	WP	RW
2	DELETED -3 COLLAR, & ADDED -9 CLAMP. REFORMATED DIMENSIONS, ADDED NEW DRAWING FORMAT AND ASSY VIEW.	5/20/08	WP	RW
2A	ADDED NOTES & CH146 TO MODELS USED ON. ALSO ADDED ALTERNATIVE O-RING. ADDED -11 SHRINK WRAP & MARK TOOL NO.	8/10/09	WP	DW
2B	ADDED LONG RANGER INFO IN MODEL USED ON	12/3/09	WP	DW
2C	CH'D TOOL NUMBER FROM H4713 TO RB H4713	10/7/10	RJC	RW
3	MODIFIED -1 TO USE WITH COUPLING, ADDED COUPLING & SPONGES. REMOVED HOSE CLAMP & SHRINK WRAP. ADDED -13, -15, -17, EXPLODED VIEWS, UPDATED BOM. INCREASED STEM LENGHT FROM .80 TO 1.35, REMOVED BARB ADDED GROOVE.	7/24/2012	JAG	SE
4	-1 CH'D ANGLE OF LOCK GROOVES SEAT WAS 60° IS 90°. CH'D DIM'S WAS .125 IS .125 +.005 -.000 $\sqrt{.090}$, WAS $\varnothing.250 \sqrt{3.07}$ IS $\varnothing.25 \sqrt{3.07}$ MAX. DELETED 6X .11, (.244), (.096). ADDED NOTES WAS .50 IS .50 NO ENGRAVING, CH'D DIM WAS 6X R.38 IS 6X R.38 EQUALLY SPACED ON $\varnothing 1.60$ B.C., CH'D NOTE WAS ENGRAVE T/N IS ENGRAVE T/N, S/N, "MADE IN USA". -11 LENGTH FROM 3.97 TO 3.86. -15 CH'D MATERIAL WAS MCMASTER-CARR #7271T32 IS NEW FIG CORP. #PAD210.	2/12/14	DPD	GE

SEE ATTACHED DEVIATION



NOTES:

1. CH146437 T/R GEAR BOX CHIP DETECTOR IS TEDECO 1B6887-2. THIS CHIP DETECTOR IS .040 SHORTER THAN DRAIN TOOL. SIMILAR TOOL REFERENCE IS DB4754.
2. USED ON MODEL BELL 407, 412, CH146, AND LONG RANGER L4 FREE WHEELING DRAIN.



RED BARN MACHINE

TITLE
TRANS. & GEAR BOX DRAIN TOOL

DWG NO.		RB H4713		REV	4
MAT'L		DRAWN BY: ROBERTS			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± 5° .X ± .1		APPROVED <i>D Weil</i>			
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		HEAT TREAT FINISH			
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SPEC			
		USED ON MODEL			
		NOTE 2			
SCALE 1:2		DATE 8/29/2000		SHEET 1 OF 2	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BODY	6061	$\varnothing 1-1/8$ X 3-1/4	2
		B/O	-5	1	O-RING	VITON	2-011N70 OR MCMASTER-CARR #9263K642	1
		B/O	-7	1	HOSE	VINYL	$\varnothing 1/2$ O.D. X $\varnothing 3/8$ I.D. X 6ft KURI-TECH #K010-0608	1
		B/O	-9	1	COUPLING	NICKEL-PLATED BRASS	$\varnothing 1/2$ MCMASTER-CARR #51495K116	1
		B/O	-11	1	TUBE	POLYETHYLENE	$\varnothing 1.09$ MCMASTER-CARR #2044T47	1
		B/O	-13	2	CAP	VINYL	$\varnothing 1.09$ MCMASTER-CARR #2044T67	1
		B/O	-15	1	FOAM	POLYESTER/POLYURETHANE	$\varnothing 1$ X 1 NEW FIG CORP. #PAD210	1